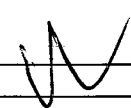
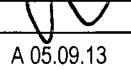


ASAP

Dart Aerospace Ltd.

Date: Thursday, 14/02/2008 9:02:10 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LUG ASSEMBLY
<b>Job Number</b> : 37412	
<b>Estimate Number</b> : 10774	
<b>P.O. Number</b> :	<b>Part Number</b> : D3414041
<b>This Issue</b> : 14/02/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3414 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 37375	<b>Material</b> :
<b>Written By</b> : 	<b>Due Date</b> : 21/02/2008 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est A 05.09.13 New issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M304S12GA	304/316 .100" Sheet
-----	-----------	---------------------



**Comment:** Qty.: 0.1523 sf(s)/Unit Total : 3.0450 sf(s)  
 304/316 stainless steel 0.100" Sheet  
 Batch: 105130 HB 8-2-14

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3414  
 Dwg Rev: A HB 8-2-14  
 Prog Rev: A

2-Deburr if necessary HB 8-2-14

(24)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-2-14

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

508/02/14 x24 counts

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



**Comment:** NC BRAKE  
 Deburr  
 Form using DT8254 as per Dwg D3414

HB 08/02/15 (29)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 14/02/2008 9:02:10 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 37412

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/15 (x24) coats

7.0

D34143

Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Lug

Pick:

Qty

Part Number Description

Batch

1

D3414-3

Lug

A/R

SS Rod

337432 ✓  
B 33376 45x ✓  
H107051 08-04-02

(24x)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using location Jig DT8484 as per Dwg D3414

08-04-02

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-04-03 (24)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/03 (x24)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

08-04-03

(24)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/4/5 (24)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 475

8/4/4 50 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 14/02/2008 9:02:10 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 37412

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

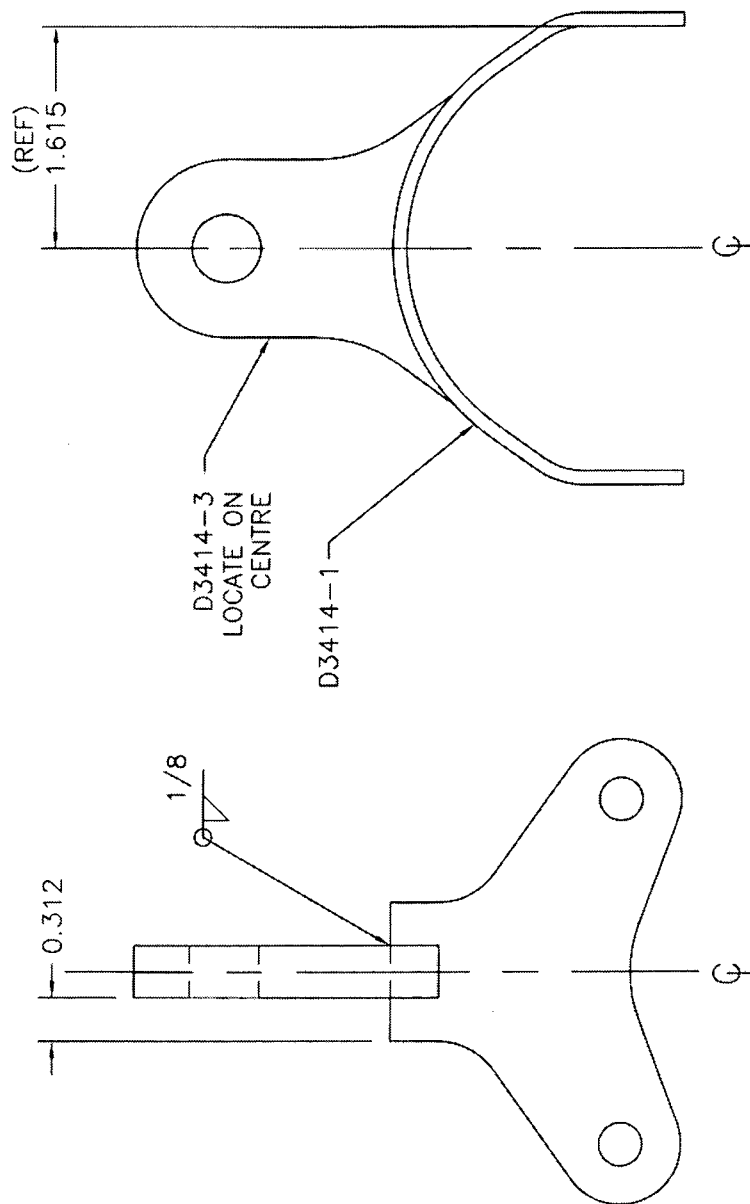


U 08-04-08



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 1 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE NTS
A	05.03.16	NEW ISSUE	

05.04.16 *[Signature]*



### D3414-041 LUG ASSEMBLY

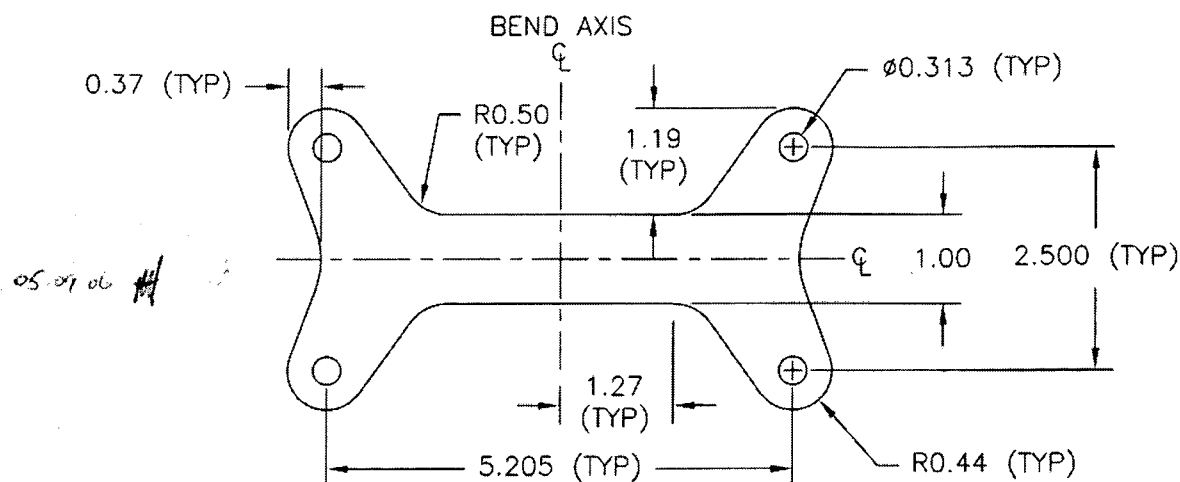
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE

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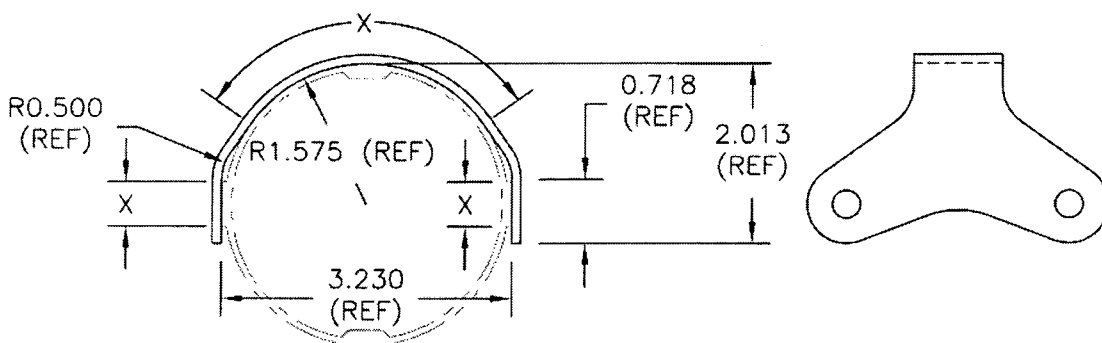


DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 2 OF 3
DATE 05.03.16	TITLE LUG ASSEMBLY		SCALE 1:2



#### **D3414-1 FLAT PATTERN**

SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)



#### **D3414-1 BEND DETAIL**

D3414-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

#### **D3414-1 LUG BRACKET**

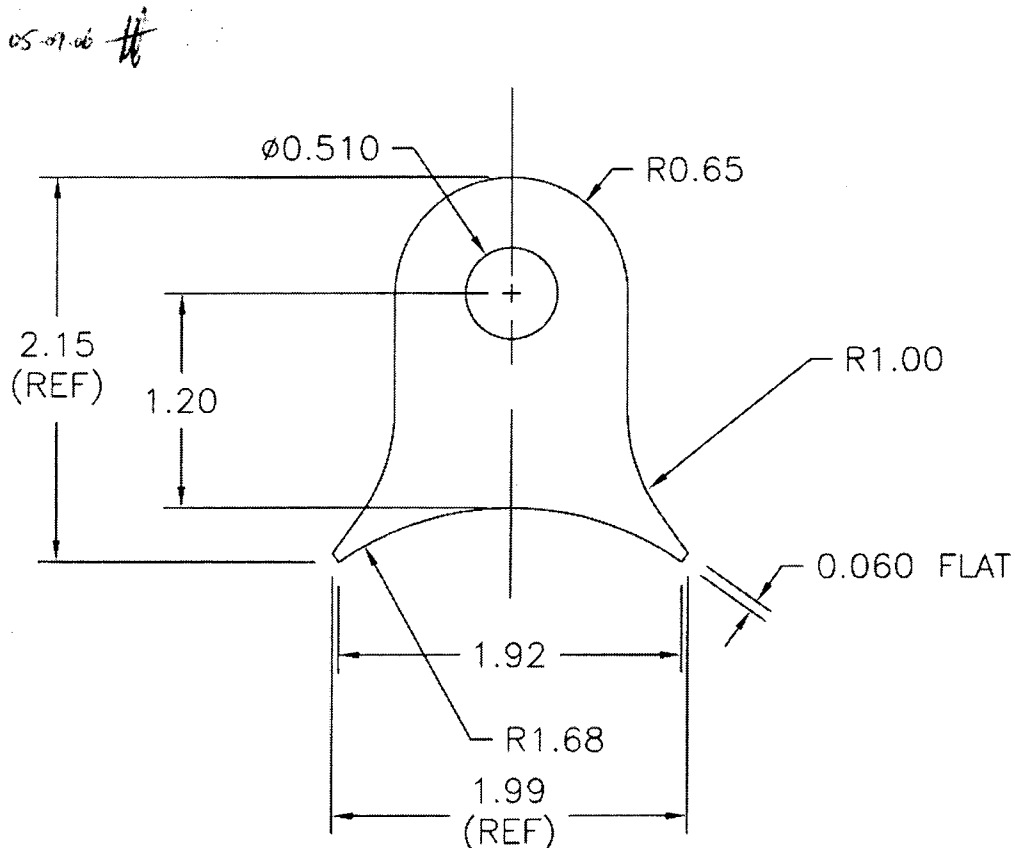
- 1) MATERIAL: AISI 304/316 SS SHEET 0.100 THICK (12 GAUGE, REF DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 3 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE 1:1



### D3414-3 LUG

- 1) MATERIAL: AISI 304/316 SS PLATE 0.375 THICK (REF DART SPEC. M304S)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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